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FOR ENGINEERING USE ONLY

D2892-1
Job Sheet 202794



Part No: D2892-1

Job Qty: 1 pcs

PRELIMINARY ISSUE

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/19

Job Tracking No: SE19-664-14

Due Date: 11/5/19

Created By: Linda Lacelle

Type: R+D

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified by: DD IPP Rev:E 11.08.04
as per dwg rev.B DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	1 pcs	11/5/19		0.36	0.85	HAAS - 1		JL. 19-11-06
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	1 pcs	11/5/19		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		



Container No: S229566



Part: D2892-1

Job No: 202794

Serial No/Batch: S229566

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/06/19

130 Crosstubes - 2 - B4B	1 pcs	11/5/19	0.00 0.16	QC 8 - 61	
				Crosstubes - 1 - B4B	
				Crosstubes - 2 - B4B	RD 19-12-3
				Crosstubes - 3 - B4B	
140 QC 3	1 pcs	11/5/19	0.00 0.00	Crosstubes - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	11/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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 4/20/2/28

180 QC 21 - SA	1 pcs	11/5/19	0.00 0.00	Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA082
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Crosstubes) Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time **3206499**
140 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

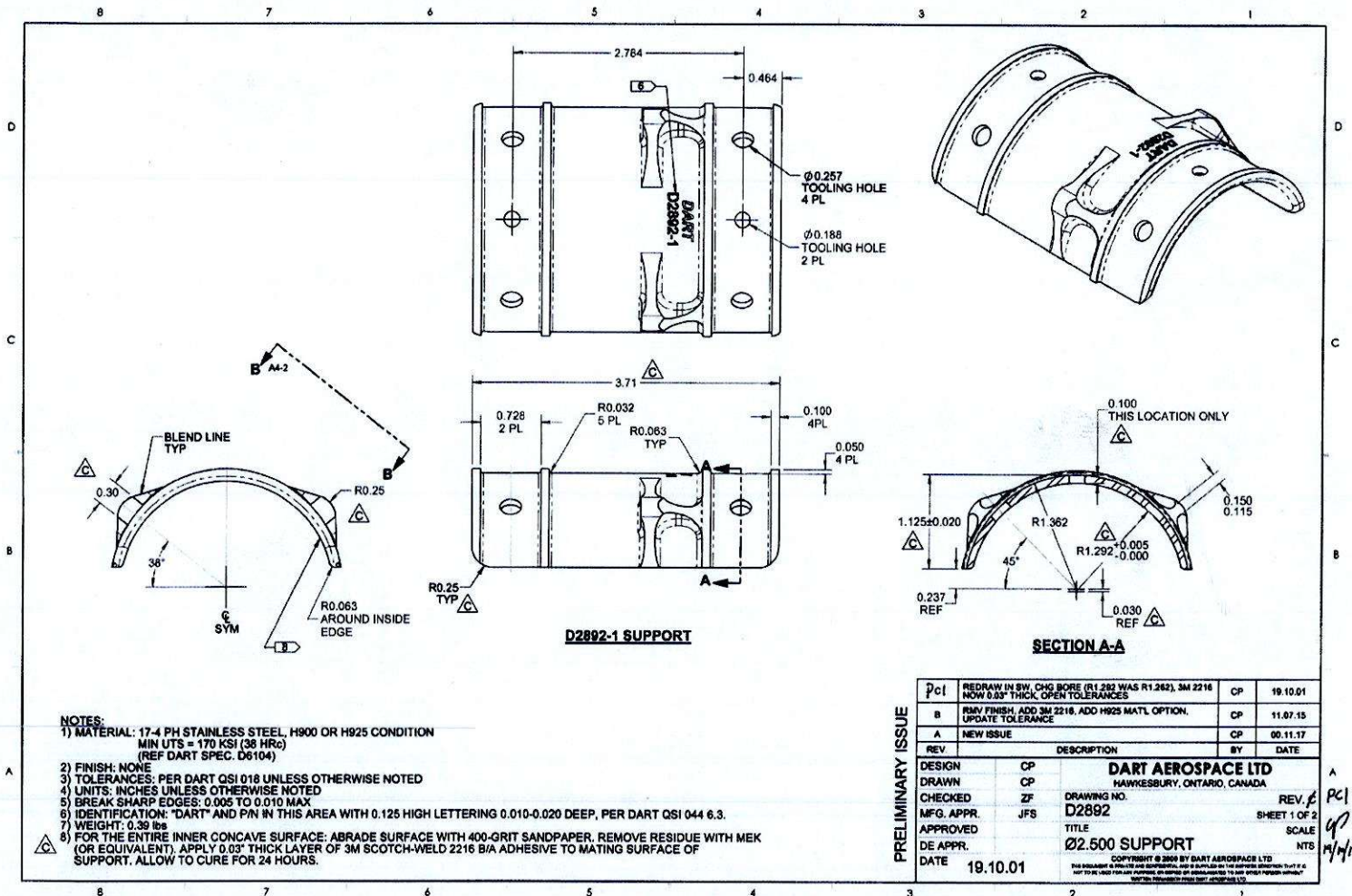
Part / Item	Component Name	Quantity	Operation	Container
D2892-1	Support	1 pcs (1 ea)	100-HAAS 4 Axis	5203970

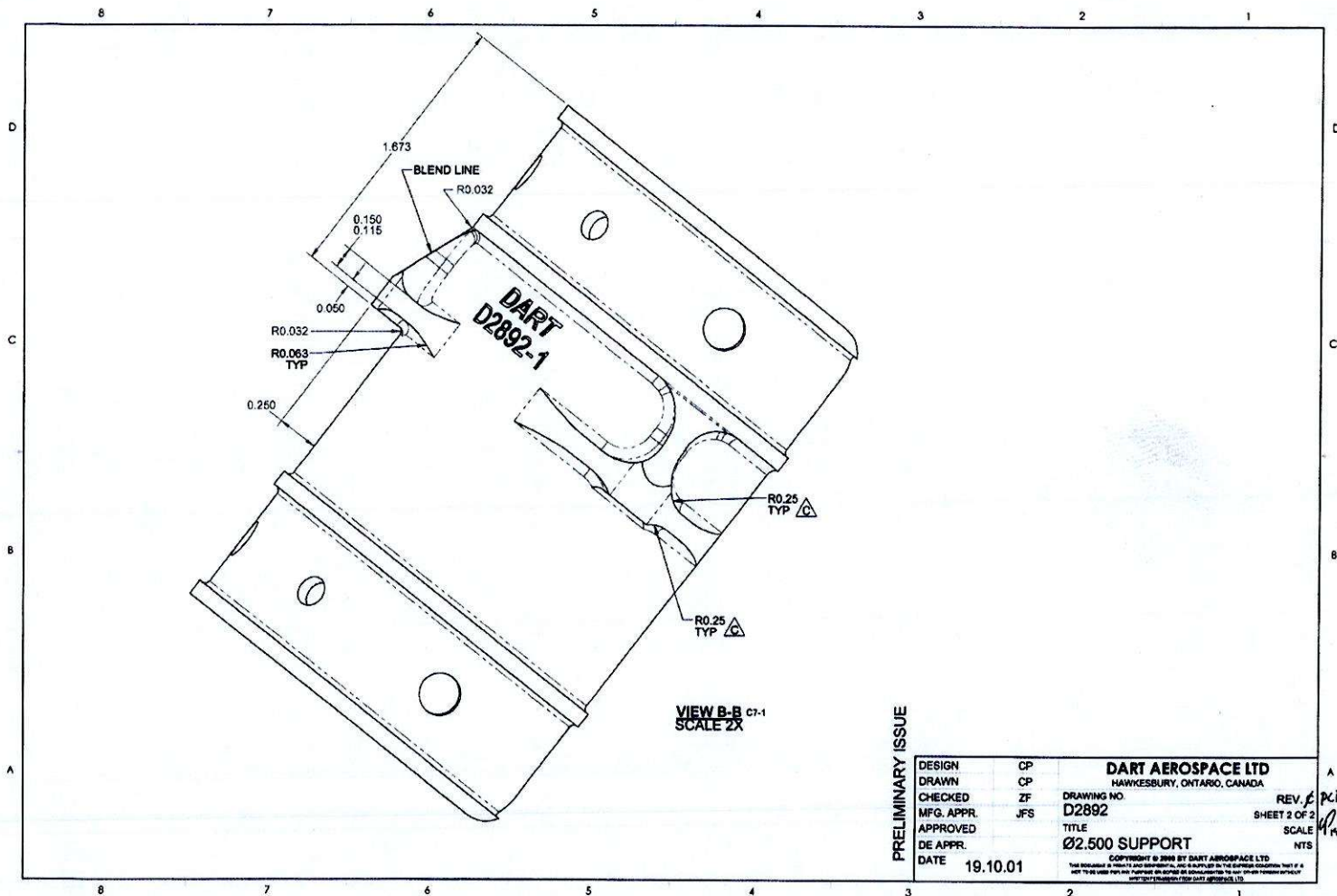
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D2892-1	1	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
2	2.250 Support	0.290Inches + 0.020 - 0.000	0.310 0.290		
3	2.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
4	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
5	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
6	2.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
7	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
8	2.250 Support	1.116Inches + 0.040 - 0.000	1.156 1.116		
9	2.250 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
10	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
11	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
12	2.250 Support	0.257Inches + 0.005 - 0.000	0.262 0.257		
13	2.250 Support	1.663Inches + 0.020 - 0.000	1.683 1.663		
14	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
15	2.250 Support	0.022Inches + 0.020 - 0.000	0.042 0.022		
16	2.250 Support	2.779Inches + 0.010 - 0.000	2.789 2.779		





PRELIMINARY ISSUE

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. 6
MFG. APPR.	JFS	D2892	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.500 SUPPORT	NTS
DATE	19.10.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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REV. 6
SHEET 2 OF 2
SCALE
NTS

Product Number (if applicable)	D206-667
Product Description	Crosstube
Accounting Job	SE19-664-14
Requested By	Chris Provencal
Date of Request	19.10.10
Requested Due Date	19.10.25

[illegible]

For preliminary part requests please ensure that the drawing at the appropriate revision is in the preliminary drawing folder and that the CAD model and DXF (if applicable) is in the Vault.